



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D3506-3

Job Sheet 202343



Part No: D3506-3

Job Qty: 20 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/19

Job Tracking No:

Due Date: 11/11/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 06-05-31 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		11/11/19	0.17	0.71	Waterjet - Flow		JRB 10/26/19
110	QC 2	20 pcs		11/11/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S226736

Part: D3506-3

Job No: 202343

Serial No/Batch: S226736

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/25/19

PRIORITY

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120 HAAS 4 Axis - B4B	20 pcs	11/11/19	1.00	1.43	HAAS - 1 - B4B	ALA/ JRB 10/26/19
					HAAS - 2 - B4B	
					HAAS - 3 - B4B	JRB 19-10-29
					HAAS - 4 - B4B	
130 QC 2	20 pcs	11/11/19	0.00	0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	JRB 19-10-29
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140 QC 8	20 pcs	11/11/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	

					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
150	Small Fab - 2 - B4B	20 pcs	11/11/19	0.00 0.23	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
160	QC 5	20 pcs	11/11/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170	Handfinish - 1-1 Chemical-B4B	20 pcs	11/11/19	0.00 0.34	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 -	

DAS
23
9-89

11/8 19/10/29

DAS
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OCT 29 2019

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OCT 29 2019

OCT 30 2019

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DAS
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OCT 30 2019

			B4B		
			Handfinish - 1 - 13 - B4B		
			Handfinish - 1 - 14 - B4B		
			Handfinish - 1 - 15 - B4B		
			Handfinish - 1 - 16 - B4B		
			Handfinish - 1 - 17 - B4B		
			Handfinish - 1 - 18 - B4B		
			Handfinish - 1 - 19 - B4B		
			Handfinish - 1 - 20 - B4B		
			Handfinish - 1 - 21 - B4B		
			Handfinish - 1 - 22 - B4B		
180 QC 7	20 pcs	11/11/19	0.00 0.00	QC 7 - 10	
			QC 7 - 13		
			QC 7 - 14		
			QC 7 - 15		
			QC 7 - 17		
			QC 7 - 18		
			QC 7 - 19		
			QC 7 - 2		
			QC 7 - 28		
			QC 7 - 3		
			QC 7 - 30		
			QC 7 - 34		
			QC 7 - 36		
			QC 7 - 37		
			QC 7 - 41		
			QC 7 - 47		
			QC 7 - 48		
			QC 7 - 51		
			QC 7 - 58		
			QC 7 - 59		
			QC 7 - 60		
			QC 7 - 9		
			QC 7 - 68		
			QC 7 - 50		
			QC 7 - 67		
			QC 7 - 40		
			QC 7 - 24		
			QC 7 - 43		
			QC 7 - 61		
			QC 7 - 81		
			QC 7 - 76		
			QC 7 - 79		
190 Packaging 3-1 - Stock - B4B	20 pcs	11/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B ✓	15001	
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		

Oscar

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DAS

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LG001

Oscar

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					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
200 QC 21 - SA	30	pcs	11/11/19	0.00 0.00	QC 21 - SA - 21✓	L5 001
					QC 21 - SA - 70	OCT 30 2019
					QC 21 - SA - 53	D46

Part Op 100 - 1-Cut as per Dwg D3506 Dwg Rev: A Prog Rev: A 2-Deburr if necessary 21
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - (HAAS CNC Vertical Machine), Machine as per Folio FA640 and Dwg D3506
 130 - QC2- Inspect parts off machine FAI/FAIB
 140 - QC8- Inspect parts - second check
 150 - C'sink as per Dwg D3506 (On Flat side)
 160 - QC5- Inspect part completeness to step on W/O
 170 - Chemical Conversion Coat per QSI005 4.1
 180 - QC7-Inspect Chemical Conversion Coat
 190 - Identify as per dwg & Stock Location: _____ LOCATION : LG001
 200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.100	6061-T6 .100 Sheet	.1560 sf (.0078 ea)	100-Waterjet - Flow - 1	5025678

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.100	0	38	0

10/25/2019

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.1385

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128inches + 0.005 - 0.001	0.133 0.127	0.120	
2	Doubler	0.277inches + 0.006 - 0.001	0.283 0.276	0.276	
3	Doubler	0.750inches $\pm$ 0.010	0.760 0.740	0.755	
4	Doubler	1.500inches $\pm$ 0.010	1.510 1.490	1.502	
5	Doubler	0.375inches $\pm$ 0.010	0.385 0.365	0.376	
6	Doubler	0.750inches $\pm$ 0.010	0.760 0.740	0.750	
7	Doubler	0.250inches $\pm$ 0.010	0.260 0.240	0.255	
8	Doubler	0.098inches $\pm$ 0.010	0.108 0.088	0.098	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐			
		Other/Details:			